

2 vs H

# Work Order ID 73334

Wednesday, August 31, 2011 11:03:41 AM



Page 1

Item ID: D2680-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-09-01

Tooling:

Date:

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2680	Rev B1								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2680 ☐ Dwg Rev: B1 ☐ Prog Rev: B1 ☐ 2-  
Deburr if necessary

1010 .063

B11-9-20

40

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-20

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/20

counts  
440

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Item Name: Nut Plate

Stop



Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr □2-C'sink as per Dwg D2680								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:30 FINISH TIME: 4:00								

*SP 11/09/22 (40)*

*count  
(+40)*

*40X DM-11/04/26*

*M 118439*

*4000F*

*3:00*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73334

Wednesday, August 31, 2011 11:03:41 AM



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Item ID: D2680-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

40  
COUNTED 8/31/09/26

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plate as per Dwg D2680

8/31/09/26 40

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/31/09/27

COUNTED  
446

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

Page 4

**Accept**

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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**Setup Start**

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

**Stop**

\_\_\_\_\_

[illegible]**Cust Item ID:**

**Start Date:** 9/1/2011      **Start Qty:** 20.00

**Required Date: 9/15/2011      Req'd Qty: 20.00**

**Customer:**

**Reference:**

Run Start

11-11-11 11:11:11

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

## Set Up/ Run Hours

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

190

Identify as per dwg & Stock Location:

0.00

**RESEARCH**

### Packaging

## Memo

0,00

## Packaging

200

QC21- Final Inspection - Work Order Release

0.00

\_\_\_\_\_

QC

## Memo

0.00

## Quality Control

11/9/27 J  
MF  
11-69-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, August 31, 2011 11:03:38 AM

Page 1

Work Order ID: 73334

Parent Item: D2680-041

Parent Item Name: Nut Plate



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D□04.10.01□Added Steps 2-4, 7-8□KJ/JLM  
IPP Rev:E Now on WaterJet 06-10-12 JLM□  
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21069L4  Nutplate		Purchased	No			110	Each	281.0000	.1	20			
<div> <div>Location</div> <div>ST302</div> <div>106285</div> </div> <div> <div>Loc Qty</div> <div>281</div> <div>281</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
M1010S16GA  1010/1025 sheet 16GA		Purchased	No			170	sf	65.3000	0.0131	0.275789			
<div> <div>Location</div> <div>MAT019</div> <div>116791</div> <div>117500</div> </div> <div> <div>Loc Qty</div> <div>65.3</div> <div>32.5</div> <div>32.8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
MS20426AD3-3  Rivet		Purchased	No			170	Each	1,797.000	2	40			
<div> <div>Location</div> <div>ST316</div> <div>19099</div> </div> <div> <div>Loc Qty</div> <div>1797</div> <div>1797</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

*EP 5/11/09/26*

*40*  
*B11-9-20 (40)*

*117500*  
*EP 5/11/09/26*

*80*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

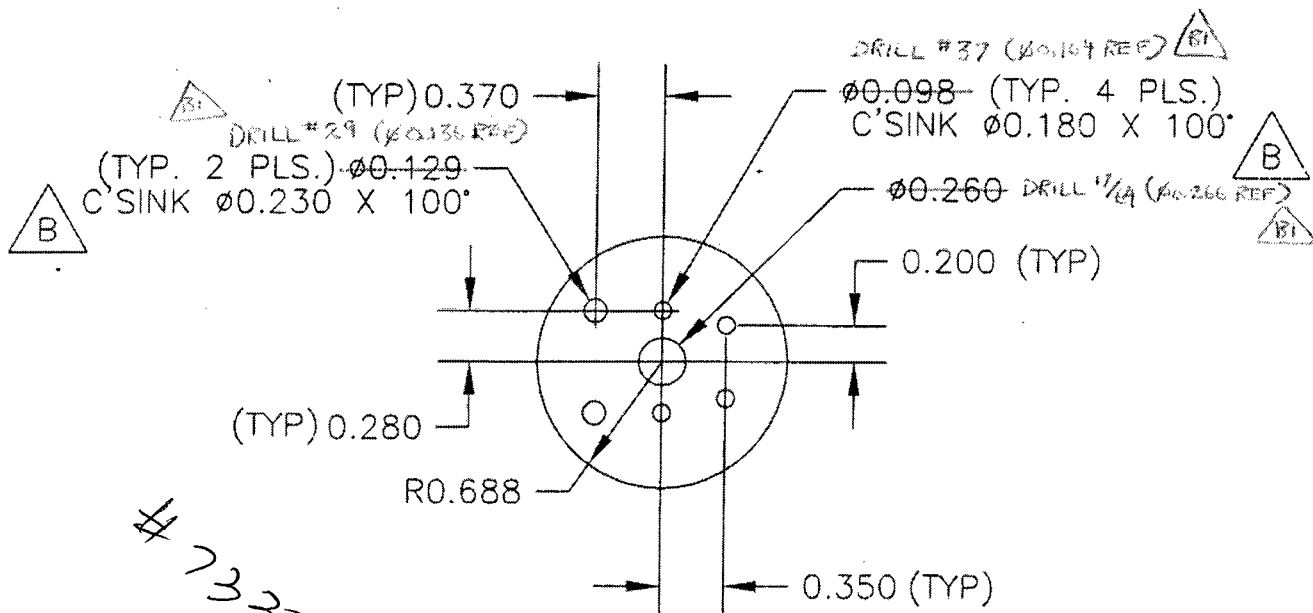
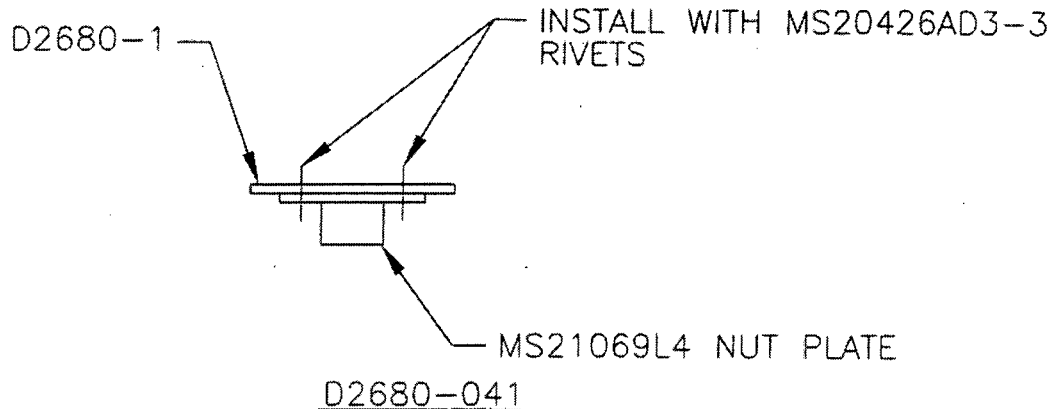
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	98.12.14	CHANGE HOLES & FINISH	

RELEASED  
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.063 THICK (16 GAUGE)

GAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

POWDER COAT WHITE (4.35.2) PER DART QSI 018 4.3  
D2680-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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